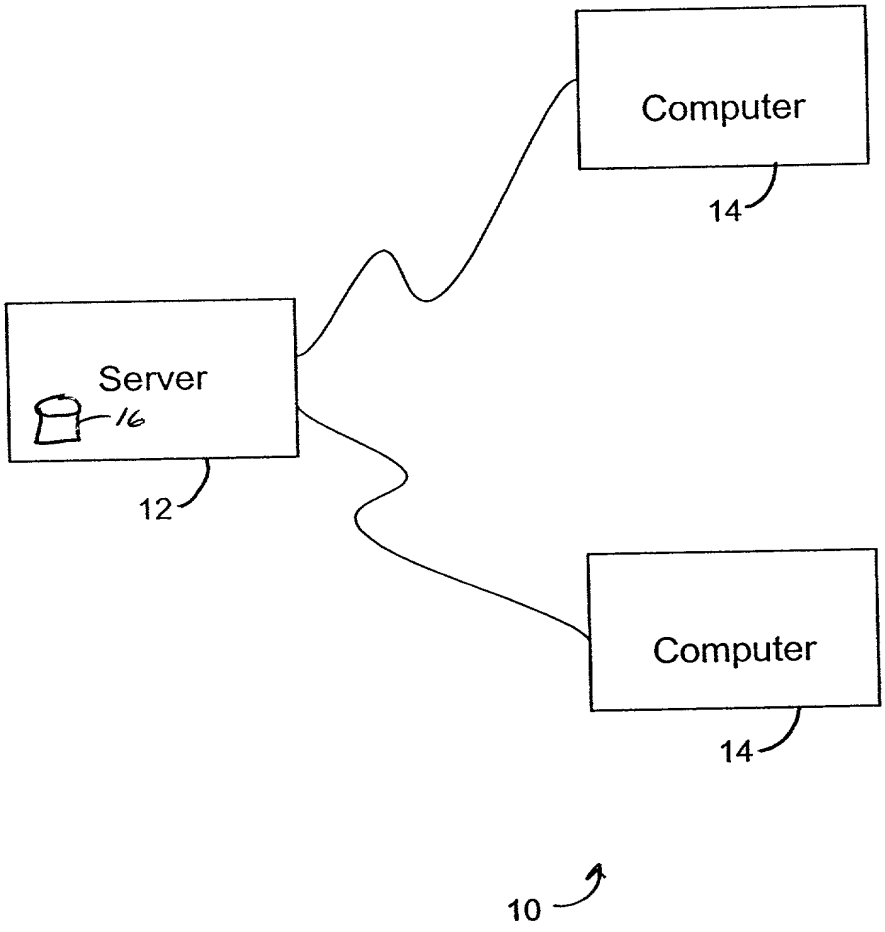
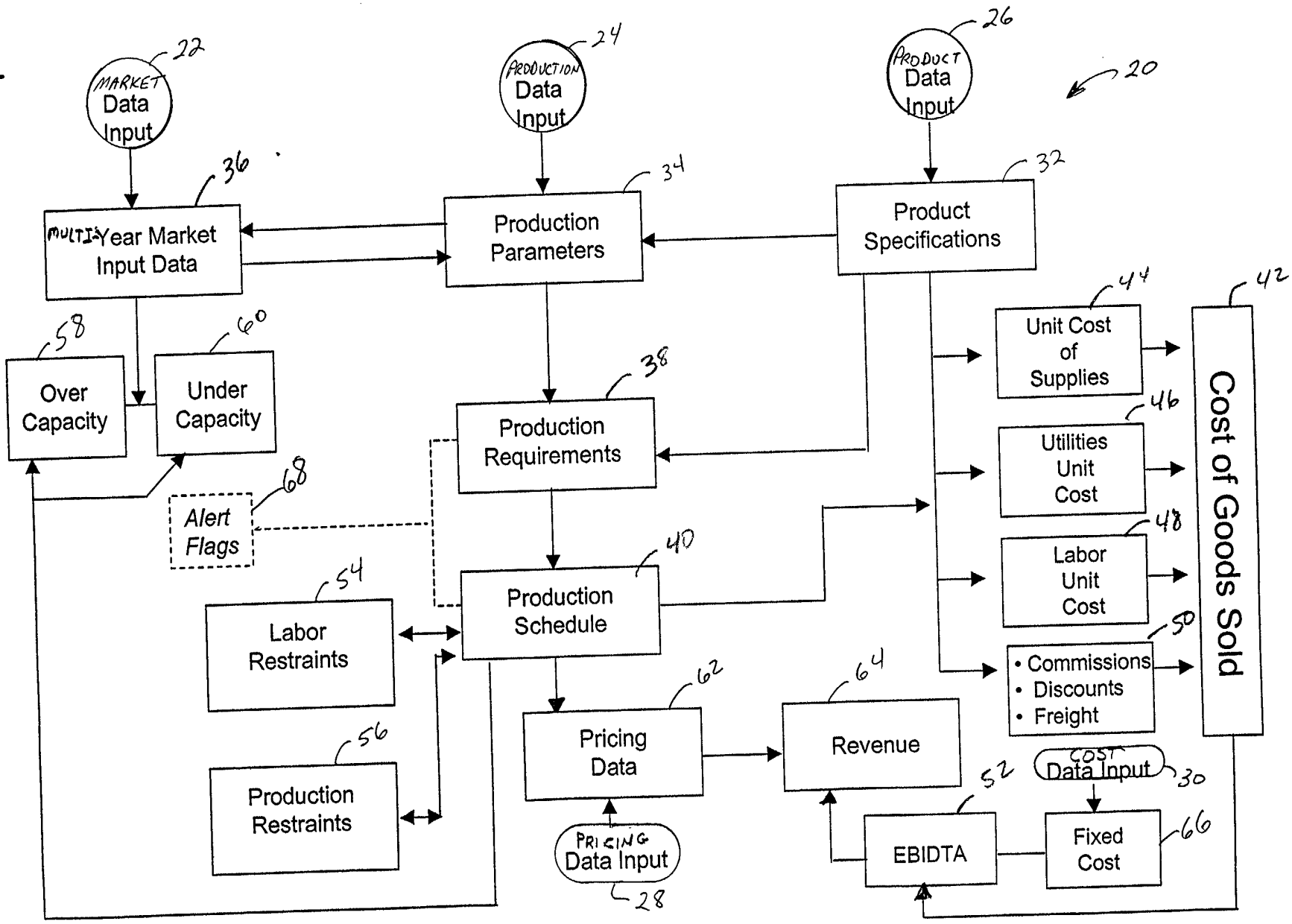
FIGURE 1




MARKET Data Input
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PRODUCTION Data Input
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PRODUCT Data Input
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MULTI-Year Market Input Data
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Production Parameters
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Revenue
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Unit Cost of Supplies
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Utilities Unit Cost
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Labor Unit Cost
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COST Data Input
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EBIDTA
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Fixed Cost
66
Cost of Goods Sold
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FIG. 2

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100

Operating Expenses

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	Jan 1999	Feb 1999	Mar 1999	Apr 1999	May 1999	June 1999	Jul 1999	Aug 1999	Sept 1999	Oct 1999	Nov 1999	Dec 1999					
		28	31	30	31	30	31	31	30	31	30	31					
Advertinsing & Promotion	1,600	1,600	1,600	1,600	1,600	1,600	1,600	1,600	1,600	1,600	1,600	1,600	19,200				
Air Freight	1,000	1,000	1,000	1,000	1,000	1,000	1,000	1,000	1,000	1,000	1,000	1,000	12,000				
Benefits	12,569	12,569	12,569	12,569	12,569	12,569	12,569	12,569	12,569	12,569	12,569	12,569	150,825				
Commissions	0	0	0	0	0	0	0	0	0	0	0	0	0				
Entertainment	8,000	8,000	8,000	8,000	8,000	8,000	8,000	8,000	8,000	8,000	8,000	8,000	96,000				
Insurance Employee	25,300	25,300	25,300	25,300	25,300	25,300	25,300	25,300	25,300	25,300	25,300	25,300	303,600				
Miscellaneous	14,000	14,000	14,000	14,000	14,000	14,000	14,000	14,000	14,000	14,000	14,000	14,000	168,000				
Office Suplies	3,400	3,400	3,400	3,400	3,400	3,400	3,400	3,400	3,400	3,400	3,400	3,400	40,800				
Postage	500	500	500	500	500	500	500	500	500	500	500	500	6,000				
Professional Fees	20,000	20,000	20,000	20,000	20,000	20,000	20,000	20,000	20,000	20,000	20,000	20,000	240,000				
Salaries	135,818	135,818	135,818	135,818	135,818	135,818	135,818	135,818	135,818	135,818	135,818	135,818	1,629,821				
Administrative hourly & benefits	12,252	11,065	12,252	11,857	12,252	11,857	12,252	12,252	11,857	12,252	11,857	12,252	144,257				
Telephone	4,025	4,025	4,025	4,025	4,025	4,025	4,025	4,025	4,025	4,025	4,025	4,025	48,300				
Travel	10,000	10,000	10,000	10,000	10,000	10,000	10,000	10,000	10,000	10,000	10,000	10,000	120,000				
Training	2,900	2,900	2,900	2,900	2,900	2,900	2,900	2,900	2,900	2,900	2,900	2,900	34,800				
Utilities Fixed	50,000	50,000	50,000	50,000	50,000	50,000	50,000	50,000	50,000	50,000	50,000	50,000	600,000				
general reduction TBD	-18,000	-18,000	-18,000	-18,000	-18,000	-18,000	-18,000	-18,000	-18,000	-18,000	-18,000	-18,000	-216,000				
Total Operating Expenses	283,364	282,177	283,364	282,969	283,364	282,969	283,364	283,364	282,969	283,364	282,969	283,364	3,397,603	3900	3900	3900	3900
Total Operating Expenses/PM-Ton	$119 79	$119 45	$106 78	$111 10	$107 34	$111 41	$126 05	$107 78	$111 71	$107 78	$111 71	$125 67	$113 50	137	137	137	137
Fixed Expenses																	
Bank Charges	2,250	2,250	2,250	2,250	2,250	2,250	2,250	2,250	2,250	2,250	2,250	2,250	27,000				
Building Repairs	18,600	18,600	18,600	18,600	18,600	18,600	18,600	18,600	18,600	18,600	18,600	18,600	223,200				
Data Processing	1,000	1,000	1,000	1,000	1,000	1,000	1,000	1,000	1,000	1,000	1,000	1,000	12,000				
Franchise Tax	5,600	5,600	5,600	5,600	5,600	5,600	5,600	5,600	5,600	5,600	5,600	5,600	67,200				
Insurance General	45,200	45,200	45,200	45,200	45,200	45,200	45,200	45,200	45,200	45,200	45,200	45,200	542,400				
Rent / Lease	19,000	19,000	19,000	19,000	19,000	19,000	19,000	19,000	19,000	19,000	19,000	19,000	228,000				
Taxes	14,000	14,000	14,000	14,000	14,000	14,000	14,000	14,000	14,000	14,000	14,000	14,000	168,000				
Total Fixed Cost	105,650	105,650	105,650	105,650	105,650	105,650	105,650	105,650	105,650	105,650	105,650	105,650	1,267,800	1300	1300	1300	1300
Total Fixed Cost/PM-Ton	$44 66	$44 72	$39 81	$41 48	$40 02	$41.59	$47 00	$40 18	$41 71	$40 18	$41 71	$46 86	$42 35	45	45	45	45
Other Income & Expenses																	
Bad Debts	2,500	2,500	2,500	2,500	2,500	2,500	2,500	2,500	2,500	2,500	2,500	2,500	30,000				
Interest	93,000	109,000	113,000	121,000	125,000	128,000	131,000	131,000	135,000	135,000	135,000	135,000	1,491,000				
Lease Amortization	433,000	433,000	433,000	433,000	433,000	433,000	433,000	433,000	433,000	450,000	450,000	450,000	5,247,000				
Supplier Rebates	0	0	0	0	0	0	0	0	0	0	0	0	0				
Other	0	0	0	0	0	0	0	0	0	0	0	0	0				
Total Other Income & Expense	528,500	544,500	548,500	556,500	560,500	563,500	566,500	566,500	570,500	587,500	587,500	587,500	6,768,000				
Total Other Income & Expense/Ton	$214 63	$221 27	$198 02	$207 36	$201 62	$209 61	$235 82	$203 28	$212 02	$210 81	$218 34	$244 61	$214 15				

FIG. 3

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Wrapper	$/M	Description
DEL12	40 3200	12 roll 280 ct
DEL2280	14 9000	2 roll 280 ct
DEL24	67 8900	24 roll 280 ct
DEL4280	20 3500	4 roll 280 ct
DEL439	22 3400	4 roll 1000 ct
DEL45/10	22 3400	4 roll 1000 ct & 500 ct
DEL6280	26 6800	6 roll 280 ct
DEL8280	25 0000	8 roll 280 ct
DEL839	33 5000	8 roll 500 ct 3 9
FED12	51 5000	12 roll 280 ct
FED2	12 9000	2 roll 280 ct
FED24	82 0000	24 roll 280 ct
FED4	38 2500	4 roll 500 ct & 1000 ct
FED4280	19 5000	4 roll 280 ct
FED6/8	33 0000	6 roll & 8 roll 280 ct
PPWRP1	10 8000	Paperwrap -1 Ply
PPWRP2	9 3000	Paperwrap -2 Ply
PPWRPDEL	20 5000	Paperwrap -Delightful
PPWRPFED	9 9000	Paperwrap -Federated
PWRP12	56 8300	12 roll 200 ct
PWRP24	89 5000	24 roll 200 ct
PWRP4	19 5000	4 roll 200 & 280 ct
PWRP6	27 2500	6 roll 200 & 280 ct
PWRP8	48 2500	8 roll 200 & 280 ct

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	Knockdowns Cost/KD	
A	Ln 1 - Non-Retail (25 50 x 17 00 x 18 25)	0 6506
B	Ln 2 - Pre 1/99 (23 50 x 15 50 x 16 75)	0 5360
C	Ln 2 - All (23 50 x 15 50 x 18 25	0 6127
D	Ln 1 - Retail (26 50 x 13 50 x 18 25)	0 7357
E	109-500 (24 ct)	0 3850
F	109-500 (48 ct)	0 5233
G	250-280 DL (48 ct)	0 4252

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Pulp & Other Supplies		OUTSIDE SALES	
Pulp $/Ton W/D	360		
Pulp $/Ton W/E	340		
Pulp Ave $/Ton	354 2857		
Chemicals $/Ton	$17 8378		
Brightener	10 5938		
PM Core $/Ton	$2 15	$15 05	$16 19
Life	7		
Cost	$25 58		$16 19 (Trebor)
Ave P R Lbs	3400		2000 (Trebor)
Fin Cores			
Core OZ/Log	5 5		
Core Stock $/Ton	$532 50		

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Parent Roll Cost/Ton Without Brightener		
Pulp	$354 29	
Chemicals	$17 84	
Core	$2 15	$15 62
Shrinkage	$36 10	
PM Waste	$1 86	
Utilities	75 19	
Labor	$47.71	
Supplies & Repairs	$79 67	
Total	**$614.80**	$628 27
Fixed Cost/Ton*	$155 85	
Total	$770 65	

*Not including interest & Lease Amortization

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Glue:

	Vendor	Qty/roll (lbs)	Line 1 $ per lb	Line 1 $/Roll	Line 2 $ per lb	Line 2 $/Roll
2865 - Hot Melt	COMPANY A	0 0001563	0 80	0 0001250	0 80	0 0001250
3369 - Hot Pick Up	COMPANY B	0 0000833	1 58	0 0001317	0 00	0 0000000
3346 - Cold Pick Up		0 0007292	0 00	0 0000000	0 73	0 0005323
3402 - Tail Tie		0 0005313	0 27	0 0001434	0 27	0 0001434
9153 - Core		0.0009167	0 34	0 0003117	0 34	0 0003117
	Total		2 99	0 0007118	2 14	0 0011124

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Wires and Felts Cost		
Wire Cost Fiscal 1998	75,603	
Tons Produced	25,767	
Wire Cost Per Ton	2 93	2 93
Felt Cost Fiscal 1998	362,424	
Tons Produced	25,767	
Felt Cost Per Ton	14 07	14 07
Total Cost Wires & Felts		17 00

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Repairs and Supplies	
Budgeted Repairs Fiscal 1999	1,866,975
Tons Produced	33,000
Cost per Ton	56 58
Budgeted Supplies Fiscal 1999	201,209
Tons Produced	33,000
Cost per Ton	6 10

Total Other Supplies & Repairs: $79 67 per Ton

FIG. 4

Utility Allocation

	Budgeted Cost Per Ton Produced
Electric	47.35
Gas	23.59
Sewer	1.46
Water	2.79
Total	75.19

Utilities charged at $76.00 for each ton produced. Allocated between papermaking and converting based upon out side parent roll sales.

Electric	
Electric cost fiscal 1998	1,220,073
Tons Produced	25,767
Cost per Ton	$47.35

Water	
Water cost fiscal 1998	71,807
Tons Produced	25,767
Cost per Ton	2.79

Gas (New supplier in 3/98)

Month	Cost per Ton
Mar-98	26.44
Apr-98	24.40
May-98	23.01
Jun-98	23.17
Jul-98	21.94
Aug-98	21.89
Sep-98	24.29
Total	165.14
Average	23.59

Sewer Month	Cost Per Month
Mar-98	-653
Apr-98	5,167
May-98	5,604
Jun-98	3,213
Jul-98	1,431
Aug-98	-449
Sep-98	5,730
Total	20,043
Tons Produced	13,708
Average	1.46

FIG. 5

BRAND COST SUMMARY

Profit/loss

PCMC Series 250 Center Winder Line 2

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Brand Code	U	T	S3	O	P	M	N	M2	NN	S2	OO	P2
Packs/Case	4	6	8	12	24	4	6	4	6	8	12	24
COST/CASE												
Paper	$2 99	$2 99	$4 61	$4 61	$4 62	$4 62	$4 62	$4 62	$4 62	$4 62	$4 62	$4 61
Chemicals	$0 15	$0 15	$0 37	$0 37	$0 37	$0 37	$0 37	$0 37	$0 37	$0 37	$0 37	$0 23
Repairs & Supplies	$0 59	$0 59	$0 91	$0 91	$0 91	$0 91	$0 91	$0 91	$0 91	$0 91	$0 91	$0 91
Utilities	$0 56	$0 56	$0 86	$0 86	$0 86	$0 86	$0 86	$0 86	$0 86	$0 86	$0 86	$0 86
Packaging												
Wrapper	$0 51	$0 47	$0 32	$0 35	$0 29	$0 53	$0 46	$0 51	$0 57	$0 43	$0 44	$0 35
KD	$0 63	$0 63	$0 63	$0 63	$0 63	$0 63	$0 63	$0 63	$0 63	$0 63	$0 63	$0 63
Fin Core Stk	$0 43	$0.43	$0 43	$0 43	$0 43	$0 43	$0 43	$0 43	$0 43	$0 43	$0 43	$0 43
Adhesives	$0 11	$0 11	$0 11	$0 11	$0 11	$0 11	$0 11	$0 11	$0 11	$0 11	$0 11	$0 11
Total Packaging	$1 67	$1 63	$1 48	$1 51	$1 45	$1 69	$1 82	$1 67	$1 73	$1 59	$1 61	$1 51
Labor	$1 49	$1 49	$2 40	$2 40	$2 47	$2 47	$2 47	$2 47	$2 47	$2 47	$2 47	$2 40
Total Variable	$7 45	$7 42	$10 64	$10 66	$10 70	$10 93	$10 86	$10 91	$10 97	$10 83	$10 85	$10 53
Indirect Operating & Fixed	$1 23	$1 23	$1 89	$1 89	$1 89	$1 89	$1 89	$1 89	$1 89	$1 89	$1 89	$1 89
Interest & Lease Amortization	$1 59	$1 59	$2 46	$2 46	$2 46	$2 46	$2 46	$2 46	$2 46	$2 46	$2 46	$2 46
Total Brand Cost/Case	***$10.28***	***$10.24***	***$14.98***	***$15.01***	***$15.04***	***$15.28***	***$15.21***	***$15.25***	***$15.32***	***$15.18***	***$15.19***	***$14.88***
Price $/Case FOB	***$9.52***	***$9.92***	***$13.15***	***$12.85***	***$11.51***	***$13.15***	***$13.15***	***$14.41***	***$15.21***	***$14.41***	***$14.41***	***$14.41***
Shipping $/Case			$2 35			$2 35	$2 35	$1 09		$1 09	$1 09	$1 09
Commission %	2 0	2 0	2 0	2 0	2 0	2 0	2 0	2 0	2 0	2 0	2 0	2 0
Price Reduction/Incr %	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0
Net Sales Price Delivered	**$9.33**	**$9.72**	**$15.24**	**$12.59**	**$11.28**	**$15.24**	**$15.24**	**$15.21**	**$14.91**	**$15.21**	**$15.21**	**$15.21**
Net Variable Contribution	**$1.87**	**$2.30**	**$4.60**	**$1.93**	**$0.58**	**$4.31**	**$4.37**	**$4.30**	**$3.93**	**$4.38**	**$4.37**	**$4.68**
Gross Profit(Loss)/case												
Before Interest & Lease	**0.65**	**1.07**	**2.71**	**0.04**	(1.31)	**2.42**	**2.48**	**2.41**	**2.04**	**2.49**	**2.47**	**2.79**
Including Interest & Lease	(0.95)	(0.52)	**0.25**	(2.42)	(3.76)	(0.04)	**0.03**	(0.04)	(0.41)	**0.04**	**0.02**	**0.34**

Legend

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Retail (4.5 x 4.09)	
U	4Pk 2Ply 200Ct
T	6Pk 2Ply 200Ct
	Total Retail
Grocery Outlet (Delightful)	
S3	8Pk 2Ply 280Ct
O	12Pk 2Ply 280Ct
P	24Pk 2Ply 280Ct
M	4Pk 2Ply 280Ct
N	6Pk 2Ply 280Ct
	Total Retail
Private Label (2 Ply 4.5x4.5 280Ct)	
M2	4 Pk 2Ply 280Ct
NN	6 Pk
S2	8 Pk
OO	12 Pk
P2	24 PK

FIG. 6

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EBITDA

	JAN	FEB	MAR	APR	MAY	JUNE	JULY	AUG	SEPT	OCT	NOV	DEC	1999	2000	2001	2002	2003
Volume																	
Converted Product - Cases	109,092	109,701	127,042	151,946	156,948	166,010	173,049	178,050	178,050	178,050	178,050	168,947	1,874,935	2,545,800	2,545,800	2,545,800	2,545,800
Parent Roll Tons	1073 9	970 5	1079 2	715 0	770 6	557 5	190.1	534.0	437 9	534 0	437 9	264 1	7564 8	197 6	197 6	286.6	375 6
Net Sales	$2,210,715	$2,272,457	$2,539,492	$2,584,889	$2,671,830	$2,648,789	$2,478,840	$2,767,606	$2,700,338	$2,767,606	$2,700,338	$2,473,870	$30,816,771	$33,778,343	$33,778,343	$33,840,669	$33,902,995
Cost of Goods Sold	$1,809,361	$1,818,455	$2,055,394	$2,060,529	$2,132,611	$2,096,875	$1,933,835	$2,187,062	$2,126,687	$2,187,062	$2,126,687	$1,920,170	$24,454,726	$26,283,460	$26,283,460	$26,339,399	$26,395,339
Gross Profit	$401,354	$454,002	$484,099	$524,361	$539,219	$551,914	$545,005	$580,544	$573,651	$580,544	$573,651	$553,701	$6,362,045	$7,494,883	$7,494,883	$7,501,270	$7,507,656
% Revenue	18 2	20 0	19.1	20 3	20.2	20 8	22.0	21.0	21 2	21 0	21 2	22 4	20 6	22.2	22.2	22 2	22.1
Fixed & Other Operating Expense																	
Case Production	$213,095	$228,440	$258,805	$301,270	$307,414	$326,090	$338,518	$344,661	$344,661	$344,661	$344,661	$327,442	$3,679,718	$4,900,824	$4,900,824	$4,900,824	$4,900,824
Parent Rolls	186,421	168,187	168,059	115,626	120,592	90,388	34,638	83,897	71,190	83,897	71,190	47,978	1,248,075	37,761	37,761	54,780	71,798
Total	$399,516	$396,627	$426,864	$416,896	$428,007	$416,478	$373,156	$428,558	$415,851	$428,558	$415,851	$375,420	$4,927,793	$4,938,586	$4,938,586	$4,955,604	$4,972,623
EBITDA	$1,838	$57,375	$57,235	$107,464	$111,213	$135,436	$171,849	$151,986	$157,800	$151,986	$157,800	$178,280	$1,434,252	$2,556,297	$2,556 297	$2,545,665	$2,535,034

FIG. 7

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FIG. 8

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1999 PRODUCTION FORECAST (PM TONS)
ROLL TISSUE

	JAN	FEB	MAR	APR	MAY	JUNE	JULY	AUG	SEPT	OCT	NOV	DEC	1999	2000	2001	2002	2003	
PM OPERATING DAYS AVAILABLE	25 0	26 0	29 0	28 0	29 0	28 0	25 0	29 0	28 0	29 0	28 0	25 0	329.0	326 0	326 0	326 0	326 0	TOT
CONVERTING DAYS AVAILABLE	29 0	26 0	29 0	28 0	29 0	28 0	26 0	29 0	28 0	29 0	28 0	27 0	336 0	335 0	335 0	335 0	335 0	TOT
YANKEE Speed FPM	3600	3600	3600	3600	3600	3600	3600	3600	3600	3600	3600	3600	3600	3610	3610	3620	3630	AVG
% Shrinkage	10 00	9 49	9 63	9 68	9 68	9 70	9 71	9 72	9 72	9 72	9 72	9 70	9 7	10 00	10 00	10 00	10 00	AVG
Gross PM Tons/Day	136 2	130 3	131 7	132 2	132 2	132 5	132 6	132 6	132 6	132 6	132 6	132 6	132.6	136 4	136 4	136 8	137 2	AVG
PM Efficiency %	85 0	85 0	85 0	85 0	85 0	85 0	85 0	85 0	85 0	85 0	85 0	85 0	85	85 0	85 0	85 0	85 0	AVG
% CREPE	14 95	14 56	14 67	14 72	14 72	14 74	14 75	14 75	14 75	14 75	14 75	14 74	14 7	14 97	14 97	14 97	14 97	AVG
% REEL DRYNESS	94	94 5	94 4	94 5	94 5	94 5	94 5	94 5	94 5	94 5	94 5	94 5	94 5	94 5	94 5	94 5	94 5	AVG
NET PM TPD, REEL	98 5	94 6	95 5	95 8	95 9	96 0	96 1	96 1	96 1	96 1	96 1	96 1	96 1	98 6	98 6	98 9	99 1	AVG
MONTH TONS PM	2,462 4	2 460 8	2,769 9	2,683 7	2 780 0	2,688 4	2 402 2	2,786 8	2 690 7	2,786 8	2,690 7	2 401 8	31,604	32 142 6	32,142 6	32 231 6	32,320 6	TOT
CONV BROKE TONS	96 9	98 4	116 1	136 7	140 1	148 4	154 2	157 7	157 7	157 7	157 7	147 0	1,669	2240 3	2240 3	2240 3	2240 3	TOT
AVE PM B W	9 276	8 873	8 966	9 002	9 004	9 020	9 028	9 029	9 029	9 029	9 029	9 025	9 026	9 262	9 262	9 262	9 262	AVG
PM Trim Width (inch) 204																		
P R SALES TONS	1 073 9	970 5	1,079 2	715 0	770 6	557 5	190 1	534 0	437 9	534 0	437 9	264 1	7,565	197 6	197 6	286 6	375 6	TOT
% TONNAGE LINE 1	60 857	65 416	60 2	57 871	56 699	57 257	56 987	55 957	55 957	55 957	55 957	58 97	58 2	59 477	59 477	59 477	59 477	AVG
% TONNAGE LINE 2	39 143	34 584	39 8	42 129	43 301	42 743	43 013	44 043	44 043	44 043	44 043	41 03	41 8	40 523	40 523	40 523	40 523	TOT
LINE 1 (SURFACE WINDER)																		
GROSS TONS	845	974 9	1017 8	1139 3	1139 3	1220 1	1260 6	1260 6	1260 6	1260 6	1260 6	1260 6	13,900 0	18999 9	18999 9	18999 9	18999 9	TOT
Ave % PM Waste	0 50	0 50	0 50	0 50	0 50	0 50	0 50	0 50	0 50	0 50	0 50	0 50	0 50	0 50	0 50	0 50	0 50	AVG
Ave % OTHER WASTE	5 50	5 77	5 72	5 69	5 69	5 68	5 67	5 67	5 67	5 67	5 67	5 67	5 70	5 50	5 50	5 50	5 50	AVG
PM TONS AVAIL	794 30	913 80	954 50	1,068 70	1 068 70	1,144 70	1,182 80	1,182 80	1,182 80	1 182 80	1 182 80	1 182 80	13,041 50	17,859 90	17 859 90	17 859 90	17 859 90	TOT
AVE SPEED	2 400 00	2 361 77	2 369 50	2,372 75	2,372 75	2 374 56	2,375 37	2,375 37	2,375 37	2 375 37	2 375 37	2,375 37	2,375 30	2,400 00	2,400 00	2 400 00	2,400 00	AVG
AVE EFF %	65 00	64 50	64 60	64 64	64 64	64 67	64 68	64 68	64 68	64 68	64 68	64 68	64 70	65 00	65 00	65 00	65 00	AVG
CASES PRODUCED																		
C & I (Old Product)																		
A S R 1000 Ct 1Ply 4 5x4 5	1,454	783	838	947	947	1 020	1,062	1,062	1,062	1,062	1 062	1,062	12,361	17 198	17,198	17 198	17,198	TOT
DD S R 500 Ct 2 Ply 4 5x3 9	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	TOT
D S R 500 Ct 2 Ply 4 5x3 9	35,100	36,965	39 537	44,702	44 702	48,137	49 865	49 865	49,865	49,865	49,865	49,865	548,333	807,837	807 837	807,837	807,837	TOT
E S R 500 Ct 2 Ply 4 5x4 5	5 741	5,948	6 362	7 193	7,193	7,746	8 012	8 012	8 012	8,012	8 012	8,012	88 255	129 795	129,795	129 795	129,795	TOT
Total C & I	42,295	43,696	46,737	52,842	52,842	56,903	58,939	58,939	58,939	58,939	58,939	58,939	648,949	954,830	954,830	954,830	954,830	TOT
Grocery Outlet																		
G 4Pk 500 Ct 2 Ply 4 5x3 9	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	TOT
F 4 Pk 500 Ct 2 Ply 4 5x4 5	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	TOT
L 4Pk 1000 Ct 1 Ply 4 5x4 5	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	TOT
J S R 500 Ct 2 Ply 4 5x3 9	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	TOT
K S R 1000 Ct 1 Ply 4 5x4 5	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	TOT
I 4 Pk 1000 Ct 1 Ply 4 5x3 9	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	TOT
Total Grocery Outlet	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	TOT
Private Label																		
JJ S R 500 Ct 2 ply 4 5x3 9	0	3,001	2,499	2 499	2,499	2,499	2,499	2,499	2 499	2,499	2,499	2,499	27,991	0	0	0	0	TOT
GG 4Pk 500 Ct 2 Ply 4 5x3 9	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	TOT
AA S R 1000 Ct 1 Ply 4 5x4 5	0	3 002	2,500	2,500	2 500	2,500	2 500	2,500	2,500	2,500	2,500	2,500	28,002	0	0	0	0	TOT
LL 4Pk 1000 Ct 1 Ply 4 5x4 5	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	TOT
FF 4 Pk 500 Ct 2 Ply 4 5x4 5	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	TOT
Total Private Label	0	6,003	4,999	4,999	4,999	4,999	4,999	4,999	4,999	4,999	4,999	4,999	55,993	0	0	0	0	TOT
*SHARES WRAPPER WITH G																		
TOTAL CASES LINE 1	42,295	49,699	51,736	57,841	57 841	61,902	63,938	63,938	63,938	63,938	63,938	63,938	704 942	954,830	954,830	954 830	954,830	TOT
LINE 2 (CENTER WINDER)																		
GROSS TONS	543 5	515 4	672 9	829 4	870 1	910 8	951 5	992 2	992 2	992 2	992 2	877 1	10,140	12945 1	12945 1	12945 1	12945 1	TOT
% PM Waste	0 50	0 43	0 45	0 46	0 46	0 47	0 47	0 47	0 47	0 47	0 47	0 46	0 50	0 50	0 50	0 50	0 50	AVG
% OTHER WASTE	8 00	6 82	7 39	7 50	7 53	7 55	7 57	7 58	7 58	7 58	7 58	7 42	7 50	8 00	8 00	8 00	8 00	AVG
PM TONS AVAIL	497 3	478 1	620 1	763 3	800 6	837 8	875 1	912 3	912 3	912 3	912 3	807 9	9,329	11844 8	11844 8	11844 8	11844 8	AVG
AVE SPEED	1,650 00	1 406 69	1,508 66	1,535 33	1,540 69	1 545 58	1,550 04	1 554 14	1 554 14	1,554 14	1 554 14	1 530 73	1,540 40	1,650 00	1 650 00	1 650 00	1 650 00	AVG
AVE EFF %	65 00	55 42	57 39	58 76	59 06	59 32	59 56	59 79	59 79	59 79	59 79	60 30	59 5	65 00	65 00	65 00	65 00	AVG
CASES PRODUCED																		
Retail (4 5 x 4 09)																		
U 4Pk 2Ply 200Ct	19,304	16,201	18,601	23,999	25,500	27 000	28 501	30,001	30 001	30,001	30,001	30,001	309,111	477,291	477,291	477 291	477,291	TOT
T 6Pk 2Ply 200Ct	47 493	37,802	43 403	55,998	59 499	63,000	66,502	70,003	70,003	70 003	70,003	70,003	723,712	1 113 679	1 113,679	1,113,679	1 113 679	TOT
Total Retail	66,797	54,003	62,004	79,997	84,999	90,000	95,003	100,004	100,004	100,004	100,004	100,004	1,032,823	1,590,970	1,590,970	1,590,970	1,590,970	TOT
Grocery Outlet																		
S3 8Pk 2Ply 280Ct	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	TOT
O 12Pk 2Ply 280Ct	0	0	796	1 603	1,603	1,603	1,603	1,603	1 603	1,603	1,603	0	13,620	0	0	0	0	TOT
P 24Pk 2Ply 280Ct	0	0	7,501	7,500	7 500	7 500	7,500	7,500	7 500	7 500	7,500	0	67,501	0	0	0	0	TOT
M 4Pk 2Ply 280Ct	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	TOT
N 6Pk 2Ply 280Ct	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	TOT
Total Retail	0	0	8,297	9,103	9,103	9,103	9,103	9,103	9,103	9,103	9,103	0	81,121	0	0	0	0	TOT
Private Label (2 Ply 4 5x4 5 280Ct)																		
M2 4 Pk 2Ply 280Ct	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	TOT
NN 6 Pk	0	5,999	5 005	5 005	5,005	5,005	5,005	5 005	5,005	5,005	5 005	5,005	56,049	0	0	0	0	TOT
S2 8 Pk	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	TOT
OO 12 Pk	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	TOT
P2 24 PK	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	TOT
Total Private Label	0	5,999	5,005	5,005	5,005	5,005	5,005	5,005	5,005	5,005	5,005	5,005	56,049	0	0	0	0	TOT
TOTAL LINE 2	66,797	60,002	75,306	94,105	99,107	104,108	109,111	114,112	114,112	114,112	114,112	105,009	1,169,993	1,590,970	1,590,970	1 590,970	1,590,970	TOT
GRAND TOTAL CASES	109,092	109,701	127,042	151,946	156,948	166,010	173,049	178,050	178,050	178 050	178,050	168,947	1,874,935	2,545 800	2,545,800	2,545,800	2,545,800	TOT
PURCHASE FIBER TON	2 455	2,453	2 757	2,652	2,749	2,647	2,345	2,740	2 641	2,740	2,641	2 351	31,172	31,295	31,295	31 388	31,480	TOT

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TABLE V
PRODUCT SPECIFICATIONS AND PERFORMANCE STANDARDS

	PCMC Surface Winder														PCMC Series 250 Center Winder											
	A	DD	D	E	G	F	L	J	K	I	JJ	GG	AA	LL	FF	U	T	S3	O	P	M	N	M2	NN	S2	OO	P2
ROLLS/PACK	1	1	1	1	4	4	4	1	1	4	1	4	1	4	4	4	6	8	12	24	4	6	4	6	8	12	24
BASIS WT	10 2	9 4	9 4	9 1	10 2	10 2	10 2	10 2	10 2	10 2	10 2	10 2	10 2	10 2	10 2	9 1	9 1	9 1	9 1	9 1	9 1	9 1	9 1	9 1	9 1	9 1	9 1
SHEET LENGTH	4 5	3 9	3 9	4 5	3 9	4 5	4 5	3 9	4 5	3 9	3 9	3 9	4 5	4 5	4 5	4 09	4 09	4 5	4 5	4 5	4 5	4 5	4 5	4 5	4 5	4 5	4 5
SHEET WIDTH	4 5	4 5	4 5	4 5	4 5	4 5	4 5	4 5	4 5	4 5	4 5	4 5	4 5	4 5	4 5	4 5	4 5	4 5	4 5	4 5	4 5	4 5	4 5	4 5	4 5	4 5	4 5
PLYS	1	2	2	2	2	2	1	2	1	1	2	2	1	1	2	2	2	2	2	2	2	2	2	2	2	2	2
SHEET COUNT	1000	500	500	500	500	500	1000	500	1000	1000	500	500	1000	1000	500	200	200	280	280	280	280	280	280	280	280	280	280
PACKS/CASE	96	48	96	96	18	18	18	72	72	18	72	18	72	18	18	24	16	12	8	4	24	16	24	16	12	8	4
ROLLS/CASE	96	48	96	96	72	72	72	72	72	72	72	72	72	72	72	96	96	96	96	96	96	96	96	96	96	96	96
UNIT WEIGHT	0 4781	0 3819	0 3819	0 4266	0 4144	0 4781	0 4781	0 4144	0 4781	0 4144	0 4144	0 4144	0 4781	0 4781	0 4781	0 1551	0 1551	0 2389	0 2389	0 2389	0 2389	0 2389	0 2389	0 2389	0 2389	0 2389	0 2389
ROLL LENGTH (FT)	375	162 5	162 5	187 5	162 5	187 5	375	162 5	375	325	162 5	162 5	375	375	187 5	68 17	68 17	105	105	105	105	105	105	105	105	105	105
SQFT/CASE	13500	5850	11700	13500	8775	10125	10125	8775	10125	8775	8775	8775	10125	10125	10125	4908 24	4908 24	7560	7560	7560	7560	7560	7560	7560	7560	7560	7560
REAMS/CASE	4 5	1 95	3 9	4 5	2 93	3 38	3 38	2 93	3 38	2 93	2 93	2 93	3 38	3 38	3 38	1 64	1 64	2 52	2 52	2 52	2 52	2 52	2 52	2 52	2 52	2 52	2 52
LBS/CASE	45 9	18 33	36 66	40 95	29 84	34 43	34 43	29 84	34 43	29 84	29 84	29 84	34 43	34 43	34 43	14 89	14 89	22 93	22 93	22 93	22 93	22 93	22 93	22 93	22 93	22 93	22 93
WINDER SPEED	2400	2400	2400	2400	2100	2100	2000	2000	2000	2000	2100	2100	2000	2000	2000	1650	1650	1650	1650	1750	1750	1750	1750	1750	1750	1750	1650
CUTS/LOG	22	22	22	22	22	22	22	22	22	22	22	22	22	22	22	22	22	22	22	22	22	22	22	22	22	22	22
LOGS/MIN	6 4	14 77	14 77	12 8	12 92	11 2	5 33	12 31	5 33	6 15	12 92	12 92	5 33	5 33	10 67	24 2	24 2	15 71	15 71	16 67	16 67	16 67	16 67	16 67	16 67	16 67	15 71
ROLL/MIN	141	325	325	282	100	246	117	271	117	135	284	100	117	117	235	532	532	346	346	367	367	367	367	367	367	367	346
CS/MIN	1 4667	6 7692	3 3846	2 9333	1 3821	3 4222	1 6298	3 7607	1 6298	1 8803	3 8487	1 3821	1 6296	1 8298	3 2593	5 5468	5 5458	3 6012	3 6012	3 8194	3 8202	3 8194	3 8194	3 8194	3 8194	3 8194	3 6012
LINE EFF %	65	65	65	65	47	47	60	60	60	60	55	47	65	60	60	65	65	60	60	55	55	55	55	55	55	55	60
WRAPPER CODE	PPWRP1	PPWRP2	PPWRP2	PPWRP2	DEL45/10	DEL45/10	DEL45/10	PPWRPDEL	PPWRP1	PPWRP1	PPWRPFED	FED4	PPWRPFED	FED4	FED4	PWRP4	PWRP8	DEL8280	DEL12	DEL24	DEL4280	DEL6280	FED4280	FED6/8	FED6/8	FED12	FED24
KD CODE	A	F	A	A	D	D	D	D	D	D	D	D	D	D	D	C	C	C	C	C	C	C	C	C	C	C	C
CORE WASTE %	6 5	6 5	6 5	6 5	7 5	7 5	6 5	6 5	6 5	6 5	6 5	7 5	6 5	6 5	6 5	6 5	6 5	6 5	6 5	6 5	6 5	6 5	6 5	6 5	6 5	6 5	6 5
WRAPPER WASTE %	8	8	8	8	8 5	8 5	8	8	8	8	8	8 5	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8
KD WASTE	2 5	2 5	2 5	2 5	2 5	2 5	2 5	2 5	2 5	2 5	2 5	2 5	2 5	2 5	2 5	2 5	2 5	2 5	2 5	2 5	2 5	2 5	2 5	2 5	2 5	2 5	2 5
PM WASTE %	0 5	0 5	0 5	0 5	0 5	0 5	0 5	0 5	0 5	0 5	0 5	0 5	0 5	0 5	0 5	0 5	0 5	0 5	0 5	0 5	0 5	0 5	0 5	0 5	0 5	0 5	0 5
OTHER CONV WASTE %	5 5	5 5	5 5	5 5	9	9	8	8	8	8	8	9	8	8	8	8	8	8	8	9	9	9	9	9	9	9	8
TOTAL PAPER WASTE %	6	6	6	6	9 5	9 5	8 5	8 5	8 5	8 5	8 5	9 5	13	8 5	8 5	8 5	8 5	8 5	8 5	9 5	9 5	9 5	9 5	9 5	9 5	9 5	8 5
CS/HR	53 80	248 20	124 10	107 50	35 30	87 30	53 70	123 90	53 70	61 90	119 23	35 30	55 30	53 70	107 40	197 90	197 90	118 60	118 60	114 10	114 10	114 10	114 10	114 10	114 10	114 10	118 60
CS/SHIFT	430 4	1985 6	992 8	860	282 4	698 4	429 6	991 2	429 6	495 2	953 9	282 4	442 4	429 6	859 2	1583 2	1583 2	948 8	948 8	912 8	912 8	912 8	912 8	912 8	912 8	912 8	948 8
TONS/SHIFT	9 88	18 2	18 2	17 61	4 21	12 02	7 4	14 79	7 4	7 39	14 23	4 21	7 62	7 4	14 79	11 79	11 79	10 88	10 88	10 47	10 47	10 47	10 47	10 47	10 47	10 47	10 88
TONS/DAY	29 84	54 6	54 6	52 83	12 63	36 06	22 2	44 37	22 2	22 17	42 69	12 63	22 86	22 2	44 37	35 37	35 37	32 64	32 64	31 41	31 41	31 41	31 41	31 41	31 41	31 41	32 64
CS/SHIFT-SHARED											671 5																
BASIS WEIGHT																											
TEST STATION BW	10 2	9 4	9 4	9 1	10 2	10 2	10 2	10 2	10 2	10 2	10 2	10 2	10 2	10 2	10 2	9 1	9 1	9 1	9 1	9 1	9 1	9 1	9 1	9 1	9 1	9 1	9 1
TS DRYNESS %	95	95	95	95	95	95	95	95	95	95	95	95	95	95	95	95	95	95	95	95	95	95	95	95	95	95	95
DRY BASIS WT	9 7	8 9	8 9	8 6	9 7	9 7	9 7	9 7	9 7	9 7	9 7	9 7	9 7	9 7	9 7	8 6	8 6	8 6	8 6	8 6	8 6	8 6	8 6	8 6	8 6	8 6	8 6
PAPER REQR'D																											
REEL DRYNESS	95	95	95	95	95	95	95	95	95	95	95	95	95	95	95	95	95	95	95	95	95	95	95	95	95	95	95
NET PAPER/CS MD	43 605	17 414	34 827	38 903	28 348	32 709	32 709	28 348	32 709	28 348	28 348	28 348	32 709	32 709	32 709	14 146	14 146	21 784	21 784	21 784	21 784	21 784	21 784	21 784	21 784	21 784	21 784
LBS BROKE/CS	2 783	1 112	2 223	2 483	2 976	3 433	3 038	2 833	3 038	2 633	2 633	2 976	4 887	3 038	3 038	1 314	1 314	2 024	2 024	2 287	2 287	2 287	2 287	2 287	2 287	2 287	2 024
GROSS PAPER/CS MD	48 830	19 500	39 000	43 564	32 972	38 044	37 628	32 612	37 628	32 612	32 612	32 972	39 575	37 628	37 628	16 273	16 273	25 060	25 060	25 337	25 337	25 337	25 337	25 337	25 337	25 337	25 060
% SHRINKAGE	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10
% CREPE	13	15	15	15	20	20	20	20	20	20	20	20	20	20	20	15	15	15	15	15	15	Y	Y	Y	15	15	15
BRIGHTENER? (Y/N)	N	N	N	N	Y	Y	Y	Y	Y	Y	Y	Y	Y	Y	Y	N	N	Y	Y	Y	Y	Y	Y	Y	Y	Y	N
GROSS FIBER/CS	54 255	21 667	43 333	48 404	36 636	42 271	41 809	36 236	41 809	36 236	36 236	36 636	43 972	41 809	41 809	18 081	18 081	27 845	27 845	28 152	28 152	28 152	28 152	28 152	28 152	28 152	27 845
LBS BROKE REUSED	2 505	1 000	2 001	2 235	2 678	3 090	2 735	2 370	2 735	2 370	2 370	2 678	4 399	2 735	2 735	1 183	1 183	1 821	1 821	2 058	2 058	2 058	2 058	2 058	2 058	2 058	1 821
BUDGET FIBER/CS MD	51 750	20 666	41 333	46 169	33 958	39 181	39 075	33 866	39 075	33 866	33 866	33 958	39 573	39 075	39 075	16 899	16 899	26 023	26 023	26 094	26 094	26 094	26 094	26 094	26 094	26 094	26 023

NOTE 4 PK IS LESS EFFICIENT DUE TO SHARED CASOLI WITH LINE 1

NOTE PRODUCT G SHARES 4 PK CASSOLI WITH LINE 2 WHEN PRODUCING PRODUCT G,
THE PRECENTAGE BELOW IS THE PERCENTAGE OF LINE #1 WINDER THAT GOES INTO PRODUCT J

65	% LINE #1 WINDER SINGLE ROLL
35	% LINE #1 WINDER 4 PACK

FIG. 9

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	31 Jan 1999	28 Feb 1999	31 Mar 1999	30 Apr 1999	31 May 1999	30 June 1999	31 Jul 1999	31 Aug 1999	30 Sept 1999	31 Oct 1999	30 Nov 1999	31 Dec 1999	Total
													0
Converting Labor & Benefits	125,000	125,000	125,000	125,000	125,000	125,000	125 000	125,000	125 000	125,000	125,000	125 000	1 500,000
Converting Overtime	20,000	23 168	25,850	24 823	25,650	24,823	25 650	25,650	24 823	25,650	24,823	25 650	296,360
Maintenance Labor Converting	19,591	17,696	19,591	18,960	19,591	18,960	19 591	19,591	18 960	19,591	18,960	19,591	230,673
Maintenance Overtime Converting	4,030	3,640	4,030	3,900	4,030	3,900	4 030	4,030	3 900	4,030	3,900	4 030	47,450
Total	168,621	169,504	174,271	172,683	174,271	172,683	174,271	174,271	172,683	174,271	172,683	174,271	2,074,483

Note The labor listed above is charged 100% to Converting products

Maintenance Labor PM	16 419	14,830	16,419	15,889	16,419	15,889	16,419	16,419	15,889	16,419	15,889	16 419	193,319
Maintenance Overtime PM	3,374	3,047	3,374	3,266	3,374	3,266	3,374	3,374	3 266	3,374	3,266	3,374	39,729
Paper Machine Labor	48,804	44,081	48,804	47,230	48,804	47,230	48,804	48,804	47,230	48,804	47 230	48,804	574,629
Paper Machine Overtime	8,037	7,259	8,037	7,777	8,037	7 777	8,037	8 037	7,777	8,037	7,777	8,037	94,626
Warehouse Labor	14,263	12,882	14 263	13,802	14,263	13,802	14,263	14,263	13,802	14,263	13,802	14,263	167,931
Warehouse Overtime	2,391	2 160	2,391	2,314	2,391	2,314	2,391	2 391	2,314	2,391	2 314	2,391	28,153
Total	93,288	84,259	93,288	90,278	93,288	90,278	93,288	93,288	90,278	93,288	90,278	93,288	1,098,387

Note The labor listed above is charged to Papermachine and Converting based upon out side parent roll sales

Maintenance Labor General	22,106	19,966	22,106	21,392	22,106	21,392	22,106	22,106	21,392	22 106	21 392	22,106	260,276
Maintenance Overtime General	1,126	1,017	1,126	1,090	1 126	1,090	1,126	1 126	1,090	1,126	1,090	1,126	13 259
Total	23,232	20,983	23,232	22,482	23,232	22,482	23,232	23,232	22,482	23,232	22,482	23,232	273,535

Note, The labor listed above will not be charged to Converting or Papermaking, instead to Facility (i e Fixed Cost)

Floor Salaries													
Converting	18,000	18,000	18,000	18,000	18,000	18 000	18,000	18,000	18,000	18,000	18,000	18,000	216,000
Paper Machine	9,753	9,753	9 753	9,753	9,753	9 753	9,753	9,753	9,753	9,753	9,753	9,753	117,038
Maintenance	17,516	17,516	17,516	17,516	17,516	17 516	17,516	17,516	17 516	17,516	17,516	17 516	210,196
Warehouse	4,458	4,458	4,458	4,458	4,458	4 458	4,458	4,458	4,458	4,458	4,458	4 458	53,498
Total	49,728	49,728	49,728	49,728	49,728	49,728	49,728	49,728	49,728	49,728	49,728	49,728	596,732

4,043 136 50

PM Labor Cost	96,896 97	89,479 97	96 896 97	94 424 97	98,896 97	94,424 97	96,896 97	96,896 97	94 424 97	96,896 97	94,424 97	96 896 97	1 145,458 60	TOT
PM Labor Cost/Ton of Production	39 35	38 36	34 98	35 18	34 86	35 12	40 34	34 77	35 09	34 77	35 09	40 34	36 36	AVE
Add'l Labor Cost for P R Sales	16 328 99	12,898 18	13,476 27	7,472 10	8,096 08	5,382 52	1,814 54	5,004 71	3,999 54	5,004 71	3,999 54	2 608 32	85,885 50	TOT
Add'l Labor Cost/Ton P R. Sales	15 21	13 08	12 49	10 45	10 51	8 66	9 54	9 37	9 13	9 37	9 13	9 88	11 35	AVE
FIN Labor Cost	193,627 43	194,510 88	199 277 53	197 689 23	199,277 53	197,689 53	199,277 53	199,277 53	197 689 53	199,277 53	197,689 53	199 277 53	2 374,561 35	TOT
FIN Labor Cost/HR of Production														
Line 1	224 48	183 88	183 13	163 19	164 51	152 91	149 53	149 53	148 34	149 53	148 34	149 53	163 91	AVE
Line 2	331 51	345 29	268 62	216 41	208 36	197 55	190 95	183 41	181 95	183 41	181 95	209 88	224 94	AVE
Warehouse Labor Cost -Production	4 783 18	6 801 99	7,635 89	13 102 06	13,016 08	15,191 64	19,297 63	16,107 46	16 574 63	16 107 46	16,574 63	18,503 85	163 696 50	TOT
Warehouse Labor Cost/Case	0 04	0 06	0 06	0 09	0 08	0 09	0 11	0 09	0 09	0 09	0 09	0 11	0 08	AVE

3,769,601 95

Difference 273,535 This labor charge is applied to fixed cost
Please see the note below the table above

Maintenance Supervision Split PM/FIN	60 % PM												
	40 % Fin												
Finishing Labor Split Line 1/Line 2													
% Line 1	42	42	42	42	42	42	42	42	42	42	42	42	42 20 AVE
% Line 2	58	58	58	58	58	58	58	58	58	58	58	58	57 80 AVE

Assumptions Included
5% wage increase, Straight Line
100% Employment
Staffing Crew

Line 1	26
Line 2	34
PM	16
PM Maint	6
Conv Maint	6
Traffic	7
General Maintenance	8
Total	103
Salaries	13

290

FIG. 10

0022T 2984260

11/15

322

Production Bottlenecks in current system

NOTES

1. When running 12 pk primary for Federated (280 ct)
   a Hayssen ultraflow is idle (Hayssen and Casmatic share a common case packer Cannot currently run both simultaneously)
   b Polywrapper is probably idle (There is no Federated 4 pk item Only 4 pk secondary item is Delightful)
   c Case packer 2 is probably idle (No 4 pk secondary item)
2. When running 6 pk primary for Federated (280 ct)
   a Hayssen and Casmatic both can run 6 pk to common case packer (Cannot run 12 pk on Casmatic)
   b Polywrapper is probably idle (There is no Federated 4 pk item Only 4 pk secondary item is Delightful)
   c Case packer 2 is probably idle (No 4 pk secondary item)
   d Can run Casmatic for Line 1 4 pk Federated items and utilize case packer #2 (will result in running Hayssen only for Line 2 production)
3. When running Line 1 4 pk for Federated (500 or 1000ct)
   a Hayssen only is available for Line 2 production (200 ct or 280 ct 6 pack) (case shifts for 4 pack "G"+"I"+"II" cannot exceed case shifts for 6 pack "T" and "NN")
   b Polywrapper is idle (Line 1 is running to case packer #2)
4. When running Line2 on 200 ct items
   a When the Casmatic is on any multi-pack item the Hayssen is idle and 4 pk is the secondary item through the Polywrapper
   b When Line 1 is on 4 pk retail items the Polywrapper is idle and only the Hayssen is available for Line 2 production

TABLE III
CONVERTING MACHINE SHIFTS REQUIRED
ROLL TISSUE

326

		JAN	FEB	MAR	APR	MAY	JUNE	JULY	AUG	SEPT	OCT	NOV	DEC	1999	2000	2001	2002	2003
LINE 1 (SURFACE WINDER)																		
C & I (Old Product)																		
A	S R 1000 Ct 1Ply 4 5x4 5	3 4	1 8	1 9	2 2	2 2	2 4	2 5	2 5	2 5	2 5	2 5	2 5	28 9	40 0	40 0	40 0	40 0
DD	S R 500 Ct 2 Ply 4 5x3 9	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0
D	S R 500 Ct 2 Ply 4 5x3 9	35 4	37 2	39 8	45 0	45 0	48 5	50 2	50 2	50 2	50 2	50 2	50 2	552 1	813 7	813 7	813 7	813 7
E	S R 500 Ct 2 Ply 4 5x4 5	6 7	6 9	7 4	8 4	8 4	9 0	9 3	9 3	9 3	9 3	9 3	9 3	102 6	150 9	150 9	150 9	150 9
	SHIFTS REQUIRED	45 5	45 9	49 1	55 6	55 6	59 9	62 0	62 0	62 0	62 0	62 0	62 0	683 6	1004 6	1004 6	1004 6	1004 6
Grocery Outlet																		
G	4Pk 500 Ct 2 Ply 4 5x3 9	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0
F	4 Pk 500 Ct 2 Ply 4 5x4 5	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0
L	4Pk 1000 Ct 1 Ply 4 5x4 5	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0
J	S R 500 Ct 2 Ply 4 5x3 9	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0
K	S R 1000 Ct 1 Ply 4 5x4 5	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0
I	4 Pk 1000 Ct 1 Ply 4 5x3 9	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0
	SHIFTS REQUIRED	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0
Private Label																		
JJ	S R 500 Ct 2 ply 4 5x3 9	0 0	3 1	2 6	2 6	2 6	2 6	2 6	2 6	2 6	2 6	2 6	2 6	29 1	0 0	0 0	0 0	0 0
GG	4Pk 500 Ct 2 Ply 4 5x3 9	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0
AA	S R 1000 Ct 1 Ply 4 5x4 5	0 0	6 8	5 7	5 7	5 7	5 7	5 7	5 7	5 7	5 7	5 7	5 7	63 8	0 0	0 0	0 0	0 0
LL	4Pk 1000 Ct 1 Ply 4 5x4 5	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0
FF	4 Pk 500 Ct 2 Ply 4 5x4 5	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0
	SHIFTS REQUIRED	0 0	9 9	8 3	8 3	8 3	8 3	8 3	8 3	8 3	8 3	8 3	8 3	92 9	0 0	0 0	0 0	0 0
	*SHARED SHIFTS DEDUCTED																	
*TOTAL SHIFTS REQUIRED *LINE 1*		45 5	55 8	57 4	63 9	63 9	68 2	70 3	70 3	70 3	70 3	70 3	70 3	776 5	1004 6	1004 6	1004 6	1004 6
LINE 2 (CENTER WINDER)																		
Retail (4 5 x 4.09)																		
U	4Pk 2Ply 200Ct	12 2	10 2	11 7	15 2	16 1	17 1	18 0	18 9	18 9	18 9	18 9	18 9	195 2	301 5	301 5	301 5	301 5
T	6Pk 2Ply 200Ct	30 0	23 9	27 4	35 4	37 6	39 8	42 0	44 2	44 2	44 2	44 2	44 2	457 1	703 4	703 4	703 4	703 4
	SHIFTS REQUIRED	42 2	34 1	39 1	50 6	53 7	56 9	60 0	63 1	63 1	63 1	63.1	63 1	652 3	1004.9	1004 9	1004 9	1004 9
Grocery Outlet (Delightful)																		
S3	8Pk 2Ply 280Ct	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0
O	12Pk 2Ply 280Ct	0 0	0 0	0 8	1 7	1 7	1 7	1 7	1 7	1 7	1 7	1 7	0 0	14 4	0 0	0 0	0 0	0 0
P	24Pk 2Ply 280Ct	0 0	0 0	8 2	8 2	8 2	8 2	8 2	8 2	8 2	8 2	8 2	0 0	73 9	0 0	0 0	0 0	0 0
M	4Pk 2Ply 280Ct	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0
N	6Pk 2Ply 280Ct	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0
	SHIFTS REQUIRED	0 0	0 0	9 0	9 9	9 9	9 9	9.9	9 9	9.9	9 9	9 9	0 0	88.3	0.0	0 0	0 0	0.0
Private Label (2 Ply 4 5x4 5 280Ct)																		
M2	4 Pk 2Ply 280Ct	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0
NN	6 Pk	0 0	6 6	5 5	5 5	5 5	5 5	5 5	5 5	5 5	5 5	5 5	5 5	61 6	0 0	0 0	0 0	0 0
S2	8 Pk	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0
OO	12 Pk	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0
P2	24 PK	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0	0 0
	SHIFTS REQUIRED	0 0	6 6	5 5	5 5	5 5	5 5	5.5	5 5	5 5	5 5	5.5	5 5	61 6	0 0	0.0	0 0	0 0
*TOTAL SHIFTS REQUIRED *LINE 2*		42 2	40 7	53 6	66 0	69 1	72 3	75 4	78.5	78.5	78 5	78 5	68 6	802 2	1004.9	1004 9	1004 9	1004 9

*PRODUCTS G/GG AND JJ SHARE SHIFTS

320

TABLE IV
EXCESS (SHORTAGE) CONVERTING CAPACITY TONNAGE
BY SHIFT SCHEDULE

328

	JAN	FEB	MAR	APR	MAY	JUNE	JULY	AUG	SEPT	OCT	NOV	DEC	1999	2000	2001	2002	2003
LINE 1 (SURFACE WINDER)																	
WEIGHTED AVERAGE TONS/SHIFT	17 49	16 35	16 62	16 73	16 73	16 79	16 82	16 82	16 82	16 82	16 82	16 82	16 79	17 78	17 78	17 78	17 78
1 SHIFT PER DAY *EXCESS (SHORTAGE)*	(433 5)	(608 6)	(609 6)	(734 5)	(722 5)	(609 5)	(870 1)	(834 1)	(846 1)	(834 1)	(816 1)	(858 1)	(9 010 2)	(13 607 4)	(13 607 4)	(13 607 4)	(13 607 4)
2 SHIFTS PER DAY *EXCESS (SHORTAGE)*	(71 2)	(305 0)	(265 4)	(399 9)	(376 0)	(473 6)	(557 7)	(485 7)	(509 7)	(485 7)	(509 7)	(533 7)	(4 9/8 5)	(9 352 8)	(9 352 8)	(9 352 8)	(9 352 8)
3 SHIFTS PER DAY *EXCESS (SHORTAGE)*	725 9	362 9	491 9	336 3	386 5	265 3	129 5	280 9	230 5	280 9	230 5	180 0	3 887 9	7 1	7 1	7 1	7 1
LINE 2 (CENTER WINDER)																	
WEIGHTED AVERAGE TONS/SHIFT	11 70	11 58	11 44	11 49	11 51	11 52	11 53	11 54	11 54	11 54	11 54	11 68	11 55	11 79	11 79	11 79	11 79
1 SHIFT PER DAY *EXCESS (SHORTAGE)*	(253 3)	(266 2)	(376 2)	(528 7)	(556 7)	(602 1)	(655 2)	(666 8)	(675 1)	(666 8)	(675 1)	(576 2)	(6 493 8)	(9 026 8)	(9 026 8)	(9 026 8)	(9 026 8)
2 SHIFTS PER DAY *EXCESS (SHORTAGE)*	(0 1)	(41 2)	(139 2)	(298 8)	(318 4)	(372 0)	(411 1)	(427 8)	(444 3)	(427 8)	(444 3)	(350 9)	(3 721 6)	(6 205 4)	(6 205 4)	(6 205 4)	(6 205 4)
3 SHIFTS PER DAY *EXCESS (SHORTAGE)*	528 2	431 8	382 1	206 9	206 0	134 8	30 0	98 1	63 5	98 1	63 5	144 9	2,377 1	1 2	1 2	1 2	1 2

TABLE VI
SHIFT SCHEDULES

324

Converting shifts (Avail) LINE 1			
shifts/day	1	2	3
hrs/shift	8	8	8
shifts/wk	5	10	21
wks/yr	48 0	48 0	48 0
shifts/yr	240 0	480 0	1008 0
Converting shifts (Avail) LINE 2			
shifts/day	1	2	3
hrs/shift	8	8	8
shifts/wk	5	10	21
wks/yr	48 0	48 0	48 0
shifts/yr	240 0	480 0	1008 0

FIG. 11

TABLE I
MARKETING FORECAST (PM TONS)
ROLL TISSUE
FIVE YEAR ROLLING FORECAST

350

Line 1, SURFACE WINDER		JANUARY 1999 %	TONS	FEBRUARY 1999 %	TONS	MARCH 1999 %	TONS	APRIL 1999 %	TONS	MAY 1999 %	TONS	JUNE 1999 %	TONS
C & I (Old Product)													
A	S R 1000 Ct 1Ply 4.5x4.5	4.2	35.5	2.2	19.1	2.2	20.5	2.2	23.1	2.2	23.1	2.2	24.9
DD	S R 500 Ct 2 Ply 4.5x3.9		0.0		0.0		0.0		0.0		0.0		0.0
D	S R 500 Ct 2 Ply 4.5x3.9	81	684.5	82.9	720.8	82.9	771.0	82.9	871.7	82.9	871.7	82.9	938.7
E	S R 500 Ct 2 Ply 4.5x4.5	14.8	125.1	14.9	129.6	14.9	138.6	14.9	156.7	14.9	156.7	14.9	168.7
	Total C & I	100	845.0	100	869.5	100	930.0	100	1,051.5	100	1,051.5	100	1,132.3
Grocery Outlet													
G	4Pk 500 Ct 2 Ply 4.5x3.9	20	0.0	20	0.0	20	0.0	20	0.0	20	0.0	20	0.0
F	4 Pk 500 Ct 2 Ply 4.5x4.5	20	0.0	20	0.0	20	0.0	20	0.0	20	0.0	20	0.0
L	4Pk 1000 Ct 1 Ply 4.5x4.5	20	0.0	20	0.0	20	0.0	20	0.0	20	0.0	20	0.0
J	S R 500 Ct 2 Ply 4.5x3.9	20	0.0	20	0.0	20	0.0	20	0.0	20	0.0	20	0.0
K	S R 1000 Ct 1 Ply 4.5x4.5	20	0.0	20	0.0	20	0.0	20	0.0	20	0.0	20	0.0
I	4 Pk 1000 Ct 1 Ply 4.5x3.9		0.0		0.0		0.0		0.0		0.0		0.0
	Total Grocery Outlet	100	0.0	100	0.0	100	0.0	100	0.0	100	0.0	100	0.0
Private Label													
JJ	S R 500 Ct 2 ply 4.5x3.9	46.4	0.0	46.42	48.9	46.42	40.8	46.42	40.8	46.42	40.8	46.42	40.8
GG	4Pk 500 Ct 2 Ply 4.5x3.9	0	0.0		0.0		0.0		0.0		0.0		0.0
AA	S R 1000 Ct 1 Ply 4.5x4.5	53.6	0.0	53.58	56.5	53.58	47.0	53.58	47.0	53.58	47.0	53.58	47.0
LL	4Pk 1000 Ct 1 Ply 4.5x4.5	0	0.0		0.0		0.0		0.0		0.0		0.0
FF	4 Pk 500 Ct 2 Ply 4.5x4.5	0	0.0		0.0		0.0		0.0		0.0		0.0
"REQUIRED" = SHARED WRAPPER LIMITATION													
	Total Private Label	100	0.0	100	105.4	100	87.8	100	87.8	100	87.8	100	87.8
	TOTAL LINE 1		845.0		974.9		1,017.8		1,139.3		1,139.3		1,220.1
Line 2, CENTER WINDER		%		%		%		%		%		%	
Retail (4.5 x 4.09)													
U	4Pk 2Ply 200Ct	28.9	157.1	30	131.8	30	151.4	30	195.3	30	207.5	30	219.7
T	6Pk 2Ply 200Ct	71.1	386.4	70	307.6	70	353.2	70	455.6	70	484.1	70	512.6
	Total Retail	100	543.5	100	439.4	100	504.5	100	650.9	100	691.6	100	732.3
Grocery Outlet (Delightful)													
S3	8Pk 2Ply 280Ct	0	0.0		0.0		0.0		0.0		0.0		0.0
O	12Pk 2Ply 280Ct	0	0.0	9.5	0.0	9.5	10.0	17.45	20.1	17.45	20.1	17.45	20.1
P	24Pk 2Ply 280Ct	0	0.0	90.5	0.0	90.5	95.0	82.55	95.0	82.55	95.0	82.55	95.0
M	4Pk 2Ply 280Ct	0	0.0		0.0		0.0		0.0		0.0		0.0
N	6Pk 2Ply 280Ct	0	0.0		0.0		0.0		0.0		0.0		0.0
	Total Retail	0	0.0	100	0.0	100	105.0	100	115.1	100	115.1	100	115.1
Private Label (2 Ply 4.5x4.5 280Ct)													
M2	4 Pk 2Ply 280Ct	0	0.0		0.0		0.0		0.0		0.0		0.0
NN	6 Pk	0	0.0	100	76.0	100	63.4	100	63.4	100	63.4	100	63.4
S2	8 Pk	0	0.0		0.0		0.0		0.0		0.0		0.0
OO	12 Pk	0	0.0	0	0.0		0.0		0.0		0.0		0.0
P2	24 PK	0	0.0		0.0		0.0		0.0		0.0		0.0
	Total Private Label	0	0.0	100	76.0	100	63.4	100	63.4	100	63.4	100	63.4
	TOTAL LINE 2		543.5		515.4		672.9		829.4		870.1		910.8
TOTAL TONNAGE REQ'D			1,388.5		1,490.3		1,690.7		1,968.7		2,009.4		2,130.9
PARENT ROLL SALES, TONS			1073.92		970.46		1079.20		714.99		770.56		557.48
PAPERMACHINE SHORTFALL TONS			0.0 FULLCAPACITY		0.0 FULLCAPACITY		0.0 FULLCAPACITY		0.0 FULLCAPACITY		0.0 FULLCAPACITY		0.0 FULLCAPACITY
CONVERTING EXCESS (SHORTFALL) TONS LINE 1 (3 SHIFT)			725.9 UNDERCAPACITY		362.9 UNDERCAPACITY		491.9 UNDERCAPACITY		338.3 UNDERCAPACITY		386.5 UNDERCAPACITY		265.3 UNDERCAPACITY
CONVERTING EXCESS (SHORTFALL) TONS LINE 2 (3 SHIFT)			528.2 UNDERCAPACITY		431.8 UNDERCAPACITY		382.1 UNDERCAPACITY		206.9 UNDERCAPACITY		206.0 UNDERCAPACITY		134.8 UNDERCAPACITY

Line 1, SURFACE WINDER		JULY 1999 %	TONS	AUGUST 1999 %	TONS	SEPTEMBER 1999 %	TONS	OCTOBER 1999 %	TONS	NOVEMBER 1999 %	TONS	DECEMBER 1999 %	TONS
C & I (Old Product)													
A	S R 1000 Ct 1Ply 4.5x4.5	2.21	25.9	2.21	25.9	2.21	25.9	2.21	25.9	2.21	25.9	2.21	25.9
DD	S R 500 Ct 2 Ply 4.5x3.9		0.0		0.0		0.0		0.0		0.0		0.0
D	S R 500 Ct 2 Ply 4.5x3.9	82.91	972.4	82.91	972.4	82.91	972.4	82.91	972.4	82.91	972.4	82.91	972.4
E	S R 500 Ct 2 Ply 4.5x4.5	14.88	174.5	14.88	174.5	14.88	174.5	14.88	174.5	14.88	174.5	14.88	174.5
	Total C & I	100	1,172.8	100	1,172.8	100	1,172.8	100	1,172.8	100	1,172.8	100	1,172.8
Grocery Outlet													
G	4Pk 500 Ct 2 Ply 4.5x3.9	20	0.0	20	0.0	20	0.0	20	0.0	20	0.0	20	0.0
F	4 Pk 500 Ct 2 Ply 4.5x4.5	20	0.0	20	0.0	20	0.0	20	0.0	20	0.0	20	0.0
L	4Pk 1000 Ct 1 Ply 4.5x4.5	20	0.0	20	0.0	20	0.0	20	0.0	20	0.0	20	0.0
J	S R 500 Ct 2 Ply 4.5x3.9	20	0.0	20	0.0	20	0.0	20	0.0	20	0.0	20	0.0
K	S R 1000 Ct 1 Ply 4.5x4.5	20	0.0	20	0.0	20	0.0	20	0.0	20	0.0	20	0.0
I	4 Pk 1000 Ct 1 Ply 4.5x3.9		0.0		0.0		0.0		0.0		0.0		0.0
	Total Grocery Outlet	100	0.0	100	0.0	100	0.0	100	0.0	100	0.0	100	0.0
Private Label													
JJ	S R 500 Ct 2 ply 4.5x3.9	46.42	40.8	46.42	40.8	46.42	40.8	46.42	40.8	46.42	40.8	46.42	40.8
GG	4Pk 500 Ct 2 Ply 4.5x3.9		0.0		0.0		0.0		0.0		0.0		0.0
AA	S R 1000 Ct 1 Ply 4.5x4.5	53.58	47.0	53.58	47.0	53.58	47.0	53.58	47.0	53.58	47.0	53.58	47.0
LL	4Pk 1000 Ct 1 Ply 4.5x4.5		0.0		0.0		0.0		0.0		0.0		0.0
FF	4 Pk 500 Ct 2 Ply 4.5x4.5		0.0		0.0		0.0		0.0		0.0		0.0
"REQUIRED" = SHARED WRAPPER LIMITATION													
	Total Private Label	100	87.8	100	87.8	100	87.8	100	87.8	100	87.8	100	87.8
	TOTAL LINE 1		1,260.6		1,260.6		1,260.6		1 260.6		1,260.6		1,260.6
Line 2, CENTER WINDER		%		%		%		%		%		%	
Retail (4.5 x 4.09)													
U	4Pk 2Ply 200Ct	30	231.9	30	244.1	30	244.1	30	244.1	30	244.1	30	244.1
T	6Pk 2Ply 200Ct	70	541.1	70	569.6	70	569.6	70	569.6	70	569.6	70	569.6
	Total Retail	100	773.0	100	813.7	100	813.7	100	813.7	100	813.7	100	813.7
Grocery Outlet (Delightful)													
S3	8Pk 2Ply 280Ct		0.0		0.0		0.0		0.0		0.0		0.0
O	12Pk 2Ply 280Ct	17.45	20.1	17.45	20.1	17.45	20.1	17.45	20.1	17.45	20.1	17.5	0.0
P	24Pk 2Ply 280Ct	82.55	95.0	82.55	95.0	82.55	95.0	82.55	95.0	82.55	95.0	82.6	0.0
M	4Pk 2Ply 280Ct		0.0		0.0		0.0		0.0		0.0		0.0
N	6Pk 2Ply 280Ct		0.0		0.0		0.0		0.0		0.0		0.0
	Total Retail	100	115.1	100	115.1	100	115.1	100	115.1	100	115.1	100.1	0.0
Private Label (2 Ply 4.5x4.5 280Ct)													
M2	4 Pk 2Ply 280Ct		0.0		0.0		0.0		0.0		0.0		0.0
NN	6 Pk	100	63.4	100	63.4	100	63.4	100	63.4	100	63.4	100	63.4
S2	8 Pk		0.0		0.0		0.0		0.0		0.0		0.0
OO	12 Pk		0.0		0.0		0.0		0.0		0.0		0.0
P2	24 PK		0.0		0.0		0.0		0.0		0.0		0.0
	Total Private Label	100	63.4	100	63.4	100	63.4	100	63.4	100	63.4	100	63.4
	TOTAL LINE 2		951.5		992.2		992.2		992.2		992.2		877.1
TOTAL TONNAGE REQ'D			2,212.1		2,252.8		2,252.8		2,252.8		2,252.8		2,137.7
PARENT ROLL SALES, TONS			190.12		534.03		437.94		534.03		437.94		264.10
PAPERMACHINE SHORTFALL TONS			0.0 FULLCAPACITY		0.0 FULLCAPACITY		0.0 FULLCAPACITY		0.0 FULLCAPACITY		0.0 FULLCAPACITY		0.0 FULLCAPACITY
CONVERTING EXCESS (SHORTFALL) TONS LINE 1 (3 SHIFT)			129.5 UNDERCAPACITY		280.9 UNDERCAPACITY		230.5 UNDERCAPACITY		280.9 UNDERCAPACITY		230.5 UNDERCAPACITY		180.0 UNDERCAPACITY
CONVERTING EXCESS (SHORTFALL) TONS LINE 2 (3 SHIFT)			30.0 UNDERCAPACITY		98.1 UNDERCAPACITY		63.5 UNDERCAPACITY		98.1 UNDERCAPACITY		63.5 UNDERCAPACITY		144.9 UNDERCAPACITY

Line 1, SURFACE WINDER		1999 TONS	2000 %	TONS	2001 %	TONS	2002 %	TONS	2003 %	TONS
C & I (Old Product)										
A	S R 1000 Ct 1Ply 4.5x4.5	301.8	2.21	419.9	2.21	419.9	2.21	419.9	2.21	419.9
DD	S R 500 Ct 2 Ply 4.5x3.9	0.0		0.0		0.0		0.0		0.0
D	S R 500 Ct 2 Ply 4.5x3.9	10,692.5	82.91	15,752.9	82.91	15,752.9	82.91	15,752.9	82.91	15,752.9
E	S R 500 Ct 2 Ply 4.5x4.5	1,922.3	14.88	2,827.2	14.88	2,827.2	14.88	2,827.2	14.88	2,827.2
	Total C & I	12,916.6	100	19,000.0	100	19,000.0	100	19,000.0	100	19,000.0
Grocery Outlet										
G	4Pk 500 Ct 2 Ply 4.5x3.9	0.0	20	0.0	20	0.0	20	0.0	20	0.0
F	4 Pk 500 Ct 2 Ply 4.5x4.5	0.0	20	0.0	20	0.0	20	0.0	20	0.0
L	4Pk 1000 Ct 1 Ply 4.5x4.5	0.0	20	0.0	20	0.0	20	0.0	20	0.0
J	S R 500 Ct 2 Ply 4.5x3.9	0.0	20	0.0	20	0.0	20	0.0	20	0.0
K	S R 1000 Ct 1 Ply 4.5x4.5	0.0	20	0.0	20	0.0	20	0.0	20	0.0
I	4 Pk 1000 Ct 1 Ply 4.5x3.9	0.0		0.0		0.0		0.0		0.0
	Total Grocery Outlet	0.0	100	0.0	100	0.0	100	0.0	100	0.0
Private Label										
JJ	S R 500 Ct 2 ply 4.5x3.9	456.5	46.42	0.0	46.42	0.0	46.42	0.0	46.42	0.0
GG	4Pk 500 Ct 2 Ply 4.5x3.9	0.0		0.0		0.0		0.0		0.0
AA	S R 1000 Ct 1 Ply 4.5x4.5	526.9	53.58	0.0	53.58	0.0	53.58	0.0	53.58	0.0
LL	4Pk 1000 Ct 1 Ply 4.5x4.5	0.0		0.0		0.0		0.0		0.0
FF	4 Pk 500 Ct 2 Ply 4.5x4.5	0.0		0.0		0.0		0.0		0.0
"REQUIRED" = SHARED WRAPPER LIMITATION		983.4								
	Total Private Label	983.4	100	0.0	100	0.0	100	0.0	100	0.0
	TOTAL LINE 1	13,900.0		19,000.0		19,000.0		19,000.0		19,000.0
Line 2, CENTER WINDER			%		%		%		%	
Retail (4.5 x 4.09)										
U	4Pk 2Ply 200Ct	2,515.1	30	3,883.5	30	3,883.5	30	3,883.5	30	3,883.5
T	6Pk 2Ply 200Ct	5,888.6	70	9,061.5	70	9,061.5	70	9,061.5	70	9,061.5
	Total Retail	8,403.7	100	12,945.0	100	12,945.0	100	12,945.0	100	12,945.0
Grocery Outlet (Delightful)										
S3	8Pk 2Ply 280Ct	0.0		0.0		0.0		0.0		0.0
O	12Pk 2Ply 280Ct	170.7	17.45	0.0	17.45	0.0	17.45	0.0	17.45	0.0
P	24Pk 2Ply 280Ct	855.1	82.55	0.0	82.55	0.0	82.55	0.0	82.55	0.0
M	4Pk 2Ply 280Ct	0.0		0.0		0.0		0.0		0.0
N	6Pk 2Ply 280Ct	0.0		0.0		0.0		0.0		0.0
	Total Retail	1,025.8	100	0.0	100	0.0	100	0.0	100	0.0
Private Label (2 Ply 4.5x4.5 280Ct)										
M2	4 Pk 2Ply 280Ct	0.0		0.0		0.0		0.0		0.0
NN	6 Pk	710.0	100	0.0	100	0.0	100	0.0	100	0.0
S2	8 Pk	0.0		0.0		0.0		0.0		0.0
OO	12 Pk	0.0		0.0		0.0		0.0		0.0
P2	24 PK	0.0		0.0		0.0		0.0		0.0
	Total Private Label	710.0	100	0.0	100	0.0	100	0.0	100	0.0
	TOTAL LINE 2	10,139.5		12,945.0		12,945.0		12,945.0		12,945.0
TOTAL TONNAGE REQ'D		24,039.5		31,945.0		31,945.0		31,945.0		31,945.0
PARENT ROLL SALES, TONS		7564.78		197.56		197.56		286.60		375.64
PAPERMACHINE SHORTFALL TONS		0.0 FULLCAPACITY		0.0 FULLCAPACITY		0.0 FULLCAPACITY		0.0 FULLCAPACITY		0.0 FULLCAPACITY
CONVERTING EXCESS (SHORTFALL) TONS LINE 1 (3 SHIFT)		3,901.09 UNDERCAPACITY		7.1 UNDERCAPACITY		7.1 UNDERCAPACITY		7.1 UNDERCAPACITY		7.1 UNDERCAPACITY
CONVERTING EXCESS (SHORTFALL) TONS LINE 2 (3 SHIFT)		2,387.60 UNDERCAPACITY		1.2 UNDERCAPACITY		1.2 UNDERCAPACITY		1.2 UNDERCAPACITY		1.2 UNDERCAPACITY

FIG. 12

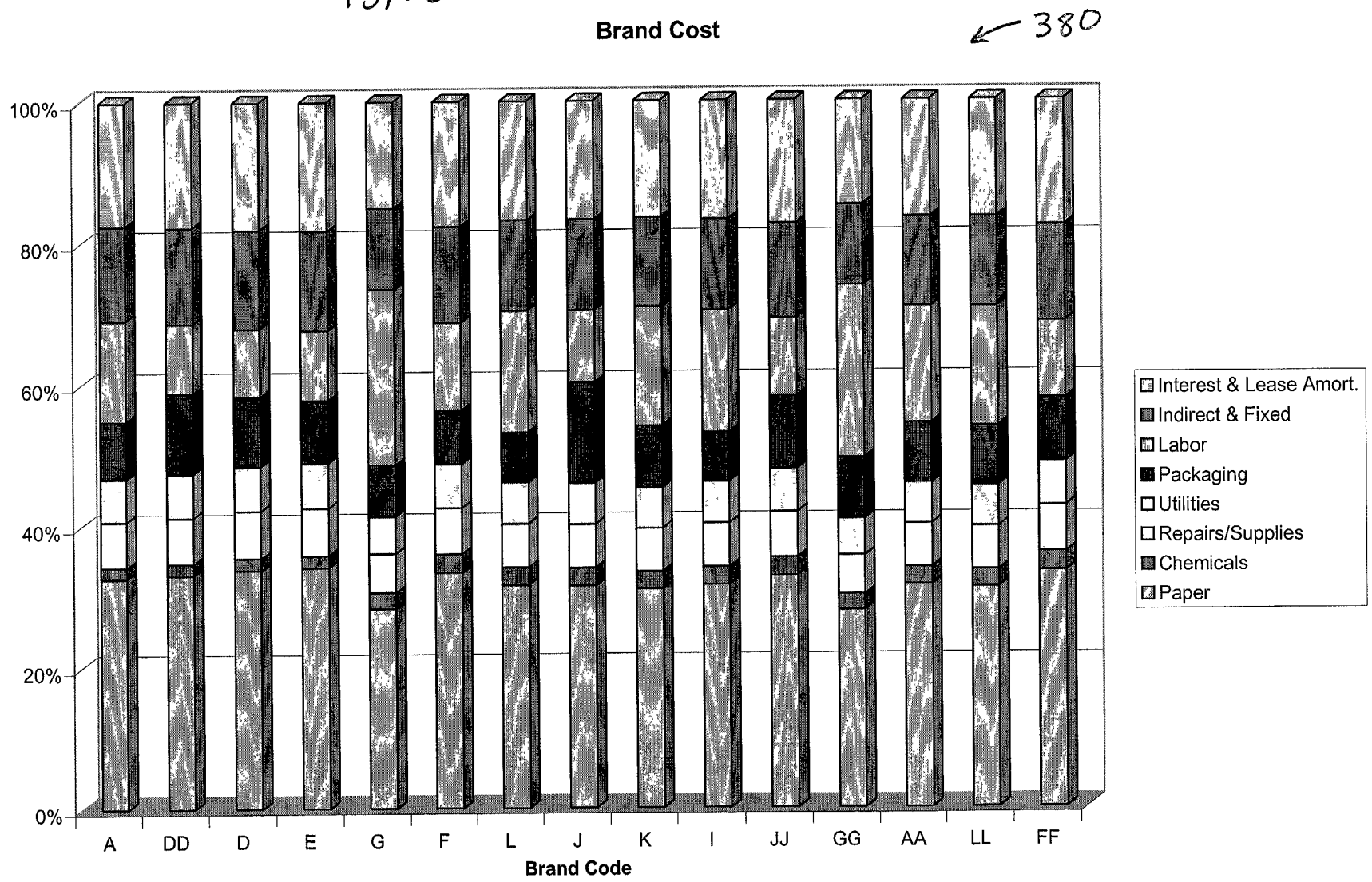
Brand Cost
380
100%
80%
60%
40%
20%
0%
A
DD
D
E
G
F
L
J
K
I
JJ
GG
AA
LL
FF
Brand Code
Interest & Lease Amort.
Indirect & Fixed
Labor
Packaging
Utilities
Repairs/Supplies
Chemicals
Paper

FIG. 13

400

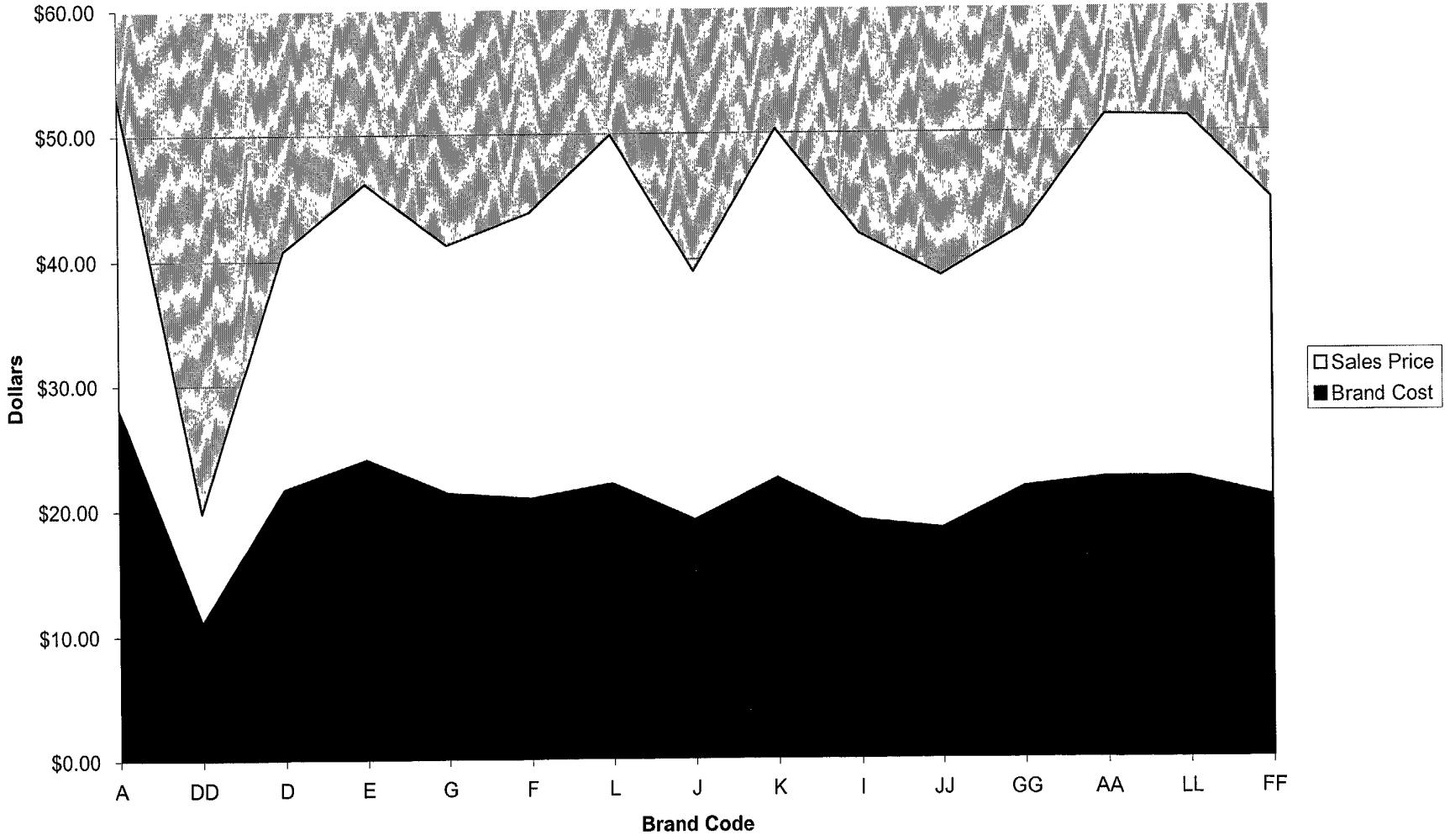
Profit Margin
$60.00
$50.00
$40.00
$30.00
$20.00
$10.00
$0.00
Dollars
A
DD
D
E
G
F
L
J
K
I
JJ
GG
AA
LL
FF
Brand Code
Sales Price
Brand Cost

FIG 14

420

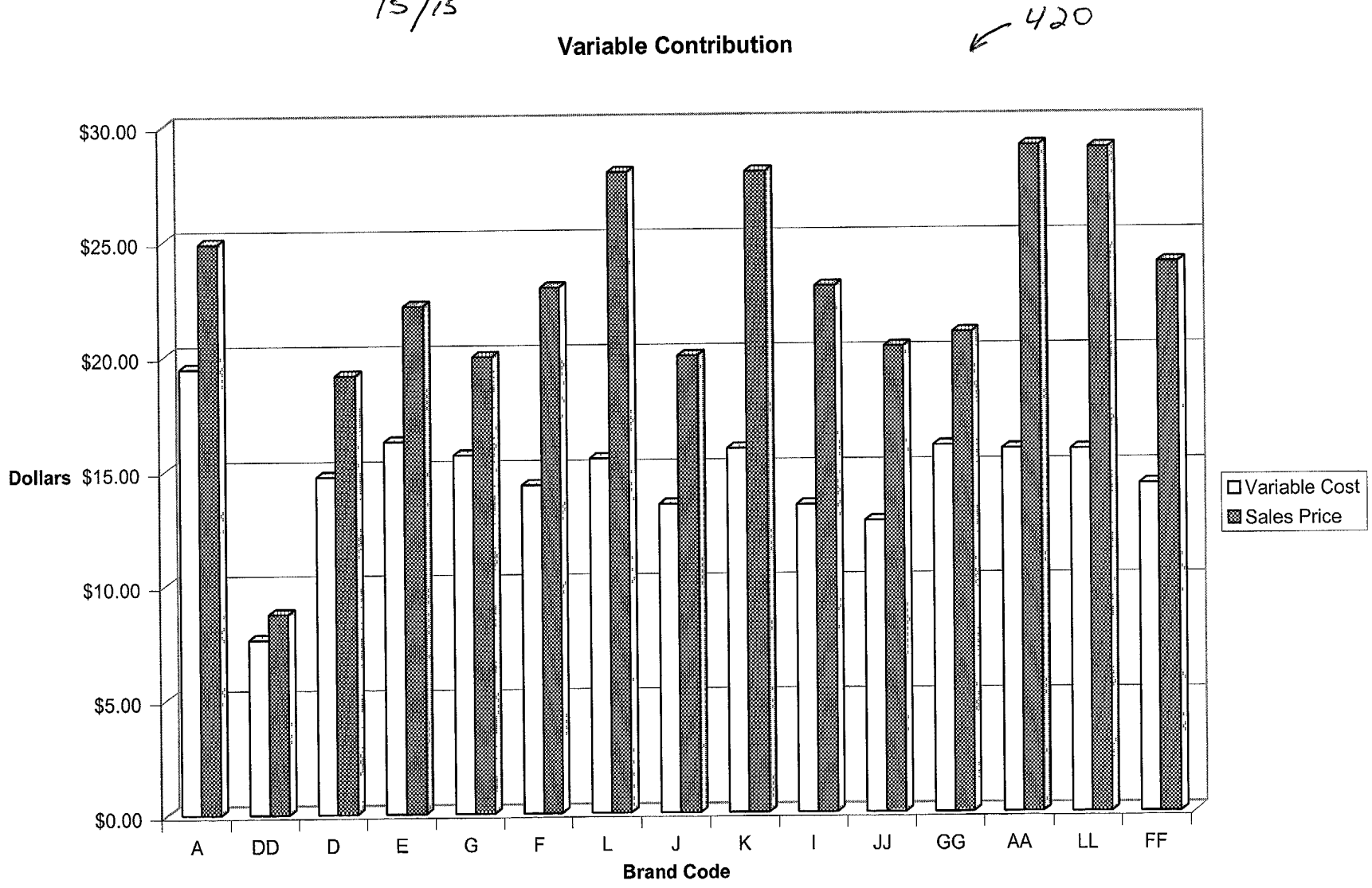
Variable Contribution
$30.00
$25.00
$20.00
$15.00
$10.00
$5.00
$0.00
Dollars
A
DD
D
E
G
F
L
J
K
I
JJ
GG
AA
LL
FF
Brand Code
Variable Cost
Sales Price

FIG. 15